Work Order I January-30-14 11:43	D 112440 3:30 AM	× 35-35	*112	2440*		,				Page 1
Revision ID: Item Name: Stair Start Date: 1/30 Required Date: 1/30	oless Steel Wearplate Aft Start Qty: 10.00	*10*	Accept	*N900 Cust Item Customer:	ID:	100)* s	Setup Star		S1* S2*
Approvals: Pro	ocess Plan:	Date: <u>14-02-03</u>	Tooling: _ SPC (Y/N):		eate:	-	I	Run Sta Sto	^ \ 	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					·				
D3535	Rev B									
*1 \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\		per Dwg D3535 Dwg Rev:_ necessary	0.00 0.00 Prog Rev:	3 _2-			10	ಲ		de 14.02.13
110 *110* QC Quality Control	QC2- Inspect parts of	f machine FAI/FAIB	0.00				_\O	_0_	<u> </u>	Ac 14.02.13
120 *120* QC	QC8- Inspect parts - s	econd check	0.00 DAS 27 0.00 3-59	113		-				

Quality Control

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		Heat Trea	at			Cut Too Short		Mislabe	eled			Power Loss/	Surge	<u>c</u>	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d						
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		Turning S	equence			Finish		Out of	Calibration						
		Wave/Tw	ist in Tub	эе		Fit/Function		Out of	Sequence						

W	ork	Order	ID	112440
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112440

Page 2 January-30-14 11:43:30 AM Item ID: D3535-35 Accept *N900040100* Setup Start **Revision ID:** Stainless Steel Wearplate Aft **Item Name:** *10* **Start Qty: 10.00 Start Date:** 1/30/14 **Cust Item ID:** Required Date: 1/30/14 Req'd Qty: 10.00 *10* **Customer:** Reference: Run Start Process Plan: Date: Tooling: **Approvals:** Date: Stop Date:_____ QC:____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Reject Insp. Accept **Work Center ID Description** Qty Qty **Run Hours** Code Number Stamp 130 0.00 NC BRAKE *130* DAS Brake NC 0.00 30 9-89 Brake NC 1-Deburr if necessary2-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326.3-Identify as D3535-35. 140 QC5- Inspect part completeness to step on W/O *140* QC 0.00 Memo Quality Control 150 Grey Sandtex(Ref: 4.3.5.6) per QSI005 4.3 0.00 10 d H-2-18. *150* Powdercoat 0.00 Memo Powder Coating

DQA:			Date:										`	
						WORK ORDER NON	-CC	ONFO	RMANCE / UF			-		AEROSPACE
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	Г	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	issing		Weld
		Cuffs				Contamination		Instruc	tions Incomplete/L	Inclear	Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	natter			Drill Holes		Off-set						
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Work Orde January-30-14					*112	24.	4 0 *							Page 3
Item ID: Revision ID: Item Name:	D3535-3	5 Steel Wearplate Aft		4	Accept	*	N900	040	100)*	Setup	Start Stop	IV	S1*
	1/30/14	Start Qty: 10.00 Req'd Qty: 10.00		*10* *10*			Cust Item 1	ID:					^IVI	S2*
Approvals:		Plan:	Date:_		Tooling:			ate:			Run	Start Stop	*N	R1*
	QC:		Date:_		SPC (Y/N):		D	ate:				•	*N	R2*
Sequence ID/ Work Center II	D	Operation Description QC3- Inspect Part Finish	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	11111	Set Up/ Run Hors 0.00 27	í,	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
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170		Identify as per dwg & Stoo	ek Locatio	on: <u>f</u> 12-66	0.00							ſ	00	
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QC21- Final Inspection - Work Order Release

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Memo

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MLJ 1402-19 MLJ 14-02-19

Quality Control

DQA:			Date:												
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January-30-14 11:43:29 AM

Work Order ID:

112440

Parent Item:

D3535-35

Parent Item Name:

Stainless Steel Wearplate Aft

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No	9		100	sf	188.5500	0.8022	8.444211	A	= 14.	02.13
304/310 .040 Sileet				Location		Loc Oty	Lo	oc Code					
				MAT020		188.55							
				m126	6852	3.55							
				m12°	7454	185			12	7454		6.8	

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	Ī					Rework			Skid-tube	Crosstube	_		Water Jet		Engineering
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		Cuffs			<u> </u>	Contamination	<u>_</u>	4	tions Incomplete/U	Inclear	_	art Moved			Wrong Stock Pulled
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]		Wave/Tw	vist in Tub	эe		Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	112440
Description: Wearshoe	Part Number:	D3535-35
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

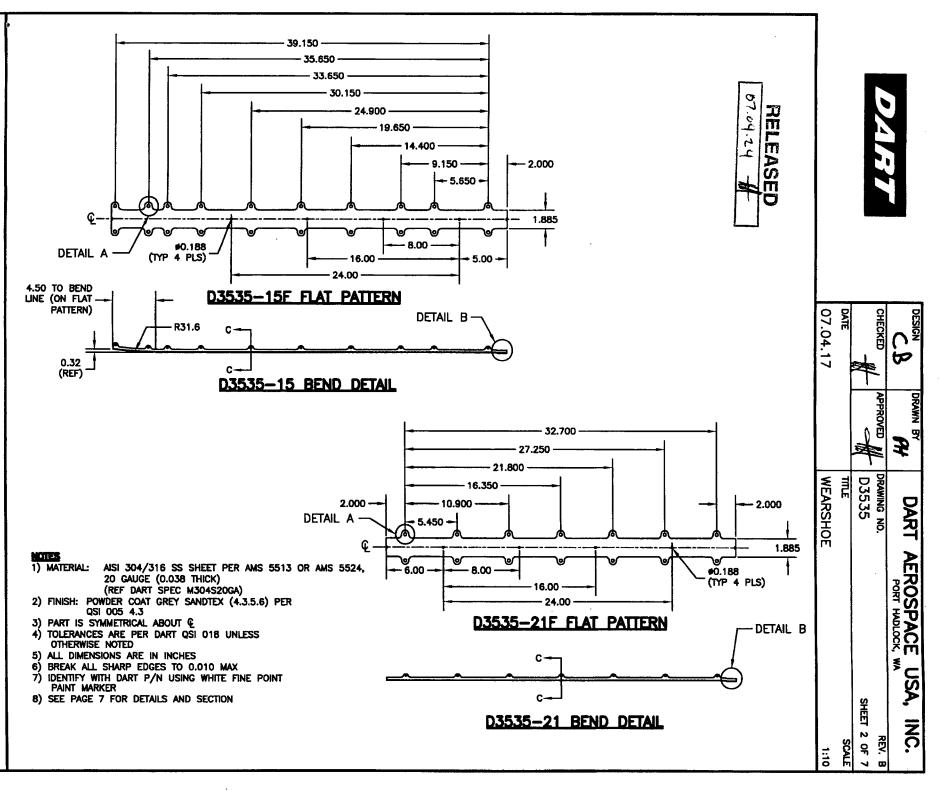
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2000			V	JKm-05
1.885	+/-0.010	1,894	•		V	
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DAS 21 Prototype Approval: Measured by: Audited by: 9-89 Date: 14.02.13 Date: N/A Date:

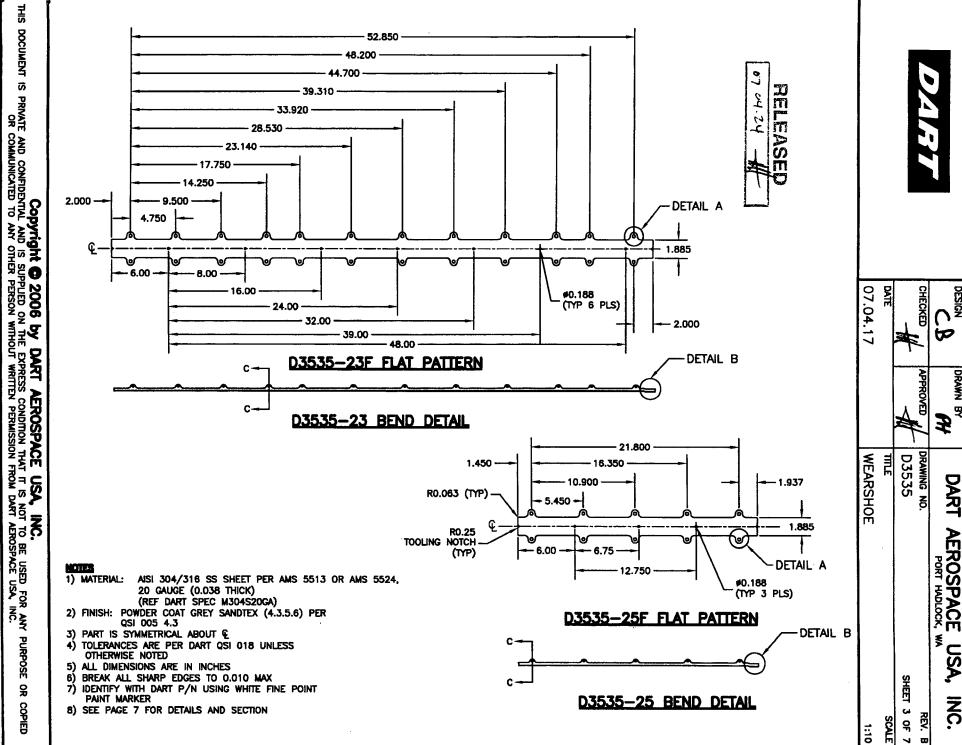
Rev	Date	Change	11011000 73/ 1.55	roved
Α	07.05.10	New Issue	KJ/JLM 🛠 📗	2

N/A



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DATE

07.04.17

WEARSHOE

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6.000 DETAIL A #0.188 (TYP 3 PLS) D3535-31F FLAT PATTERN



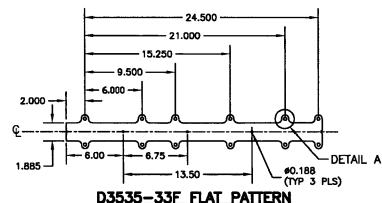
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D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN

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D353	5-33 BEND	DETAIL	

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1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

BREAK ALL SHARP EDGES TO 0.010 MAX

7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

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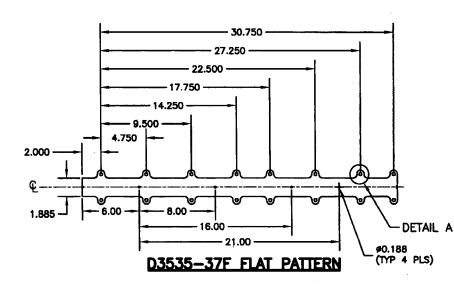
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23.250 19.750 17.750 14.250 9.500 4.750 2.000 #0.188 (TYP 2 PLS) 1.885 D3535-35F FLAT PATTERN D3535-35 BEND DETAIL

DETAIL A



D3535-37 BEND DETAIL

AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA) 1) MATERIAL:

QREF LIANT SMEU MJU4SZUGA)

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

5) ALL DIMENSIONE ARE

5) ALL DIMENSIONS ARE IN INCHES

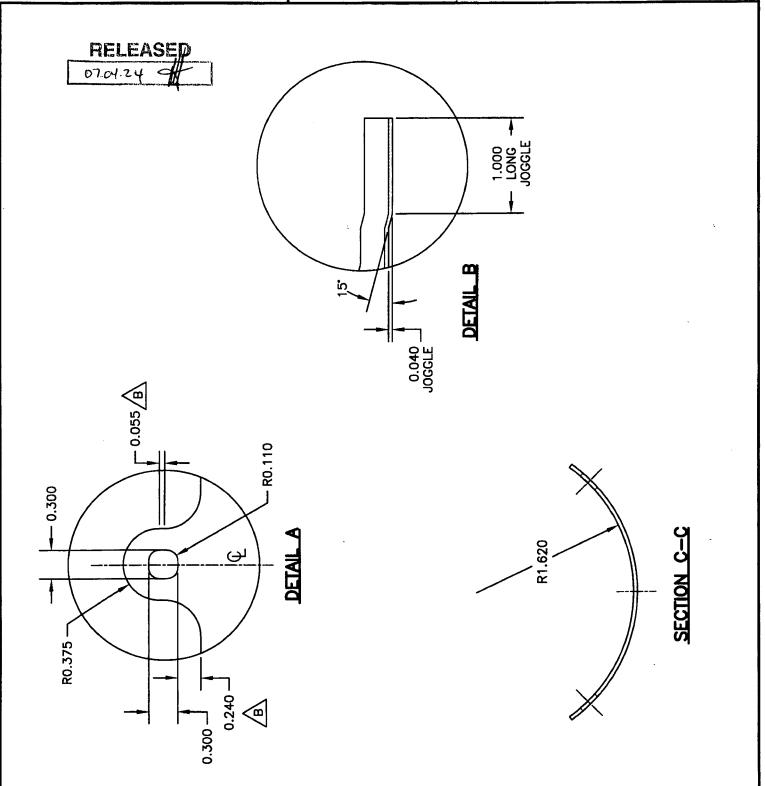
BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION



DESIGN	DRAWN BY	DART	AEROSPACE USA, INC.
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		D3535	SHEET 7 OF 7
DATE	•	TITLE	SCALE
07.04.17		WEARSHOE	1:1



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